

CLAIMS

1. A method of manufacturing boards from lignocellulose-containing material in which the material is disintegrated into particles and/or fibres, glue-coated, and
5 formed into a mat, wherein the formed mat is compressed in a first step to provide board of generally uniform density which is then pressed in a second step to form a finished board, **characterized** by subjecting the board between said first step and said second step to an intermediate step in the form of at least one operation of machining by cutting in which a pattern is formed on or in the board while re-
10 taining the essentially uniform density of the board.

2. A method according to claim 1, **characterized** by pressing the board in said second step such as to retain the pattern that was produced by machining
15 said board.

3. A method according to any one of the preceding claims, **characterized** in that said board machining operation includes at least one milling operation.

4. A method according to any one of the preceding claims, **characterized** by
20 modifying the surface layer of the board after said intermediate step and before said second step.

5. A method according to any one of the preceding claims, **characterized** by modifying the surface layer of the board in conjunction with said second step.

6. A method according to any one of claims 4-5, **characterized** in that modification of the surface layer of the board includes the accomplishment of a sealing surface layer on said board.

7. A method according to any one of claims 4-6, **characterized** in that modification of the surface layer of said board includes applying a pre-glued film to said board.

8. A method according to any one of claims 4-6, **characterized** in that modification of the surface layer of said board includes applying a laminate to said board.

9. A method according to any one of the preceding claims, **characterized** by forming a further pattern on the board prior to or in conjunction with said second step.

10. A method according to any one of the preceding claims, **characterized** by densifying the surface layer of the board when pressing said board in the second step.

11. A method according to any one of the preceding claims, **characterized** by returning at least part of the material removed during said machining operation back to the inflow of raw material to the board manufacturing process.

12. An arrangement for carrying out the method according to any one of claims 1-11, comprising an arrangement for carrying out the first step of said method and including a pre-press (1) in which a mat is compressed into a board that has a generally uniform density, at least one station that includes a cutting machine (2; 32) for carrying out the intermediate step of said method, and a press (3; 33) for carrying out the second step of said method.

13. An arrangement according to claim 12, **characterized** in that the cutting machine in said station includes at least one milling machine (2; 32).

14. An arrangement according to any one of claims 12-13, **characterized** by an arrangement (22; 52) for modifying the surface layer of the board subsequent to said intermediate step.

15. An arrangement according to claim 14, characterized in that the arrangement (22; 52) for modifying the surface layer of the board after said intermediate step includes means for applying reinforcing and/or sealing material to said board.
16. An arrangement according to any one of claims 12-15, characterized in that the press for carrying out the second step of the method is a continuous press (3) whose press elements in contact with the board are provided with the same pattern as that produced in the intermediate step.
17. An arrangement according to any one of claims 12-15, characterized in that it also includes means (30) for cutting the board into lengths; and in that the press for carrying out the second step of the method is a discontinuous press (33) whose press elements in contact with the board are provided with the same pattern as that produced in the intermediate step of said method.
18. An arrangement according to any one of claims 12-17, characterized in that the press (3; 33) for carrying out the second step of the method also includes means for densifying the surface layer of the board.

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